

Alu. Tube 0312 x .058" wall

Work Order ID [77501]

December-09-11 8:50:36 AM

Page 1

Item ID: D3681-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 09/12/2011 Start Qty: 80.00

80

Cust Item ID:

Required Date: 16/12/2011 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 11/12/09

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3681	Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: 4A

DWG REV: 4

2-DEBURR AS REQUIRED

80

0

11/12/13

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

80

0

11/12/13

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11/12/13

80

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77501

December-09-11 8:50:36 AM

77501

Page 2

Item ID: D3681-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 09/12/2011 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 16/12/2011 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
125									
Skidtubes	Memo	0.00							
Skidtubes	1- clean crossbolt spacer with ultra brighth aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location <u>LG</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

80 D BE 12-01-06

80 D BE 12-01-06

12/1/10
MF
12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-09-11 8:50:41 AM

Page 1

Work Order ID: 77501

77501

Parent Item: D3681-1

D3681-1

Parent Item Name: Spacer

Start Date: 09/12/2011

Required Date: 16/12/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD
seq 125 DD 10.05.03 verified by:EC

IPP Rev:C add

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased		No		100	f	261.1230	0.34	28.63158			

M6061T6T0 3125W 058

ALUM TUBE .3125 x .058w

**

28.250'

11/12/13

Location

MAT013

Loc Qty

261.123

Loc Code

116793

1.667

116939

23.972

117400

16.9

118438

14.584

119678

204

4.250'

24.000'

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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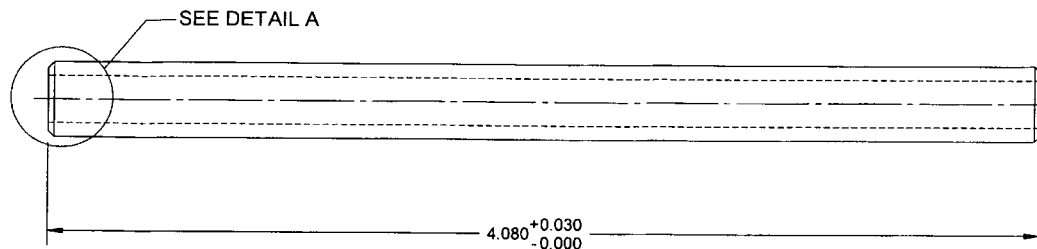
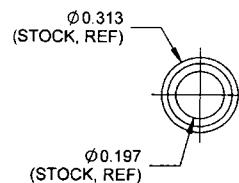
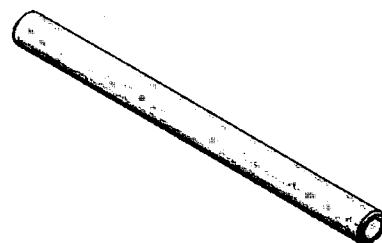
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NOTE: Date & initial all entries

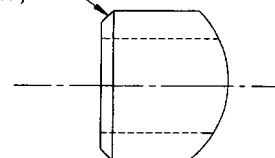


D3681-1 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77501 M.C.J

11/12/09

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
07-11-09

A		NEW ISSUE		DC	07.11.08
REV	DESCRIPTION			BY	DATE
DESIGN	DC	DART AEROSPACE USA, INC.		REV. A	
DRAWN	SC	PORT HADLOCK, WA		SHEET 1 OF 1	
CHECKED	MS	DRAWING NO.	D3681		
MFG. APPR.	EP	TITLE	SPACER		
APPROVED	W	SCALE	2:1		
DE APPR.	#	DATE 07.11.08			
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